

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: ARM		
Job Number	: 29786				
Estimate Number	: 11048				
P.O. Number	: N/A	Part Number	: D28443		
This Issue	: 12/5/2006	S.O. No.	: N/A	Drawing Number	: D2844 REV A
Prsht Rev.	: NC			Project Number	: N/A
First Issue	: N/A	Type	: MACHINED PARTS	Drawing Revision	: A
Previous Run	: N/A			Material	: N/A
Written By	: 	Due Date	: 12/20/2006	Qty:	10 Um: Each
Checked & Approved By	:  06 12 05				
Comment	: Est: B 00.11.01 Removed P/O for Powder Coat - in house processEC				

Job Number:



1.0	M304TR0500W035	304 RD Tube .500 x .035W
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304 RD Tube .500 x .035W

Punch 304/316 Seamless tubing with 2B finish, 1/2" OD x .035 Wall 21.49" long (Hole ctr. to hole ctr.) using Jig

DT 8012

Batch M 102958

2.0// ~~BAND SAW~~ ~~BRAKE~~ ~~NK~~ BAND SAW



~~Comment: BAND SAW~~

Form per Dwg D2844 using brake and bending jig DT 8238-B

Deburr

3.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

4.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3

5.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: DP Date: 07/01/22
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 12/5/2006 8:16:16 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ARM

Job Number: 29786

Part Number: D28443

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *SH62*

EP 11/01/22 (10) 12/01/22

7.0

QC21

FINAL INSPECTION/W/O RELEASE



(10)

Comment: FINAL INSPECTION/W/O RELEASE

12/01/22

Job Completion



U 07/06/22

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

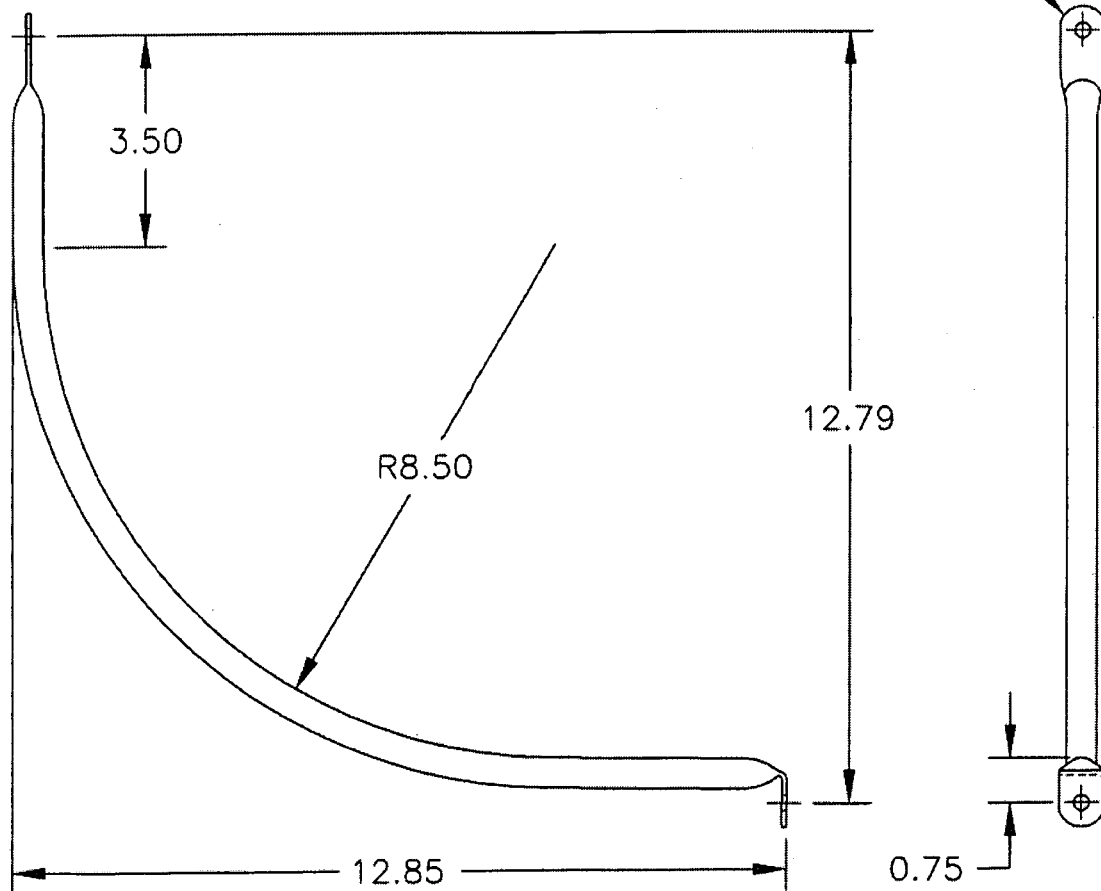
NOTE: Date & initial all entries



DESIGN <i>KE</i>	DRAWN BY <i>KE</i>	DART AEROSPACE USA, INC. FAIRCHILD INTERNATIONAL AIRPORT, WA	
CHECKED <i>DAH</i>	APPROVED <i>CS</i>	DRAWING NO. D2844	REV. A SHEET 1 OF 2
DATE 98.10.14		TITLE ARM	SCALE 1:3
A	98.10.14	NEW ISSUE	

RELEASED
98.11.11 *KE*

PUNCH ENDS PER SPEC CONTROL DRAWING D2727



D2844-1

MATERIAL: AISI 304/316 SS TUBE, $\varnothing 0.50 \times 0.035$ WALL
ENSURE TUBE IS SEAMLESS

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3

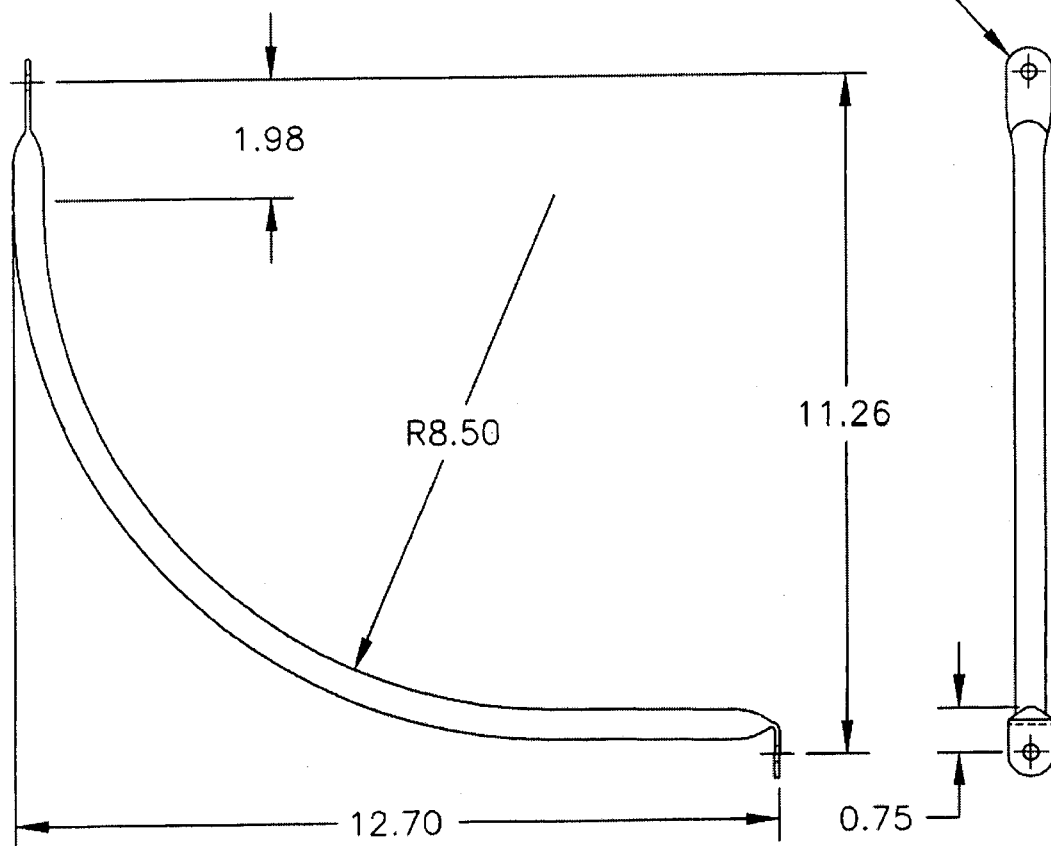
SHOP COPY
RETURN TO
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UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 29786



DESIGN <i>KE</i>	DRAWN BY <i>KE</i>	DART AEROSPACE USA, INC. FAIRCHILD INTERNATIONAL AIRPORT, WA	
CHECKED <i>DA</i>	APPROVED <i>KE</i>	DRAWING NO. D2844	REV. A SHEET 2 OF 2
DATE 98.10.14		TITLE ARM	SCALE 1:3

RELEASED
98.11.11 KE

PUNCH ENDS PER SPEC CONTROL DRAWING D2727



D2844-3

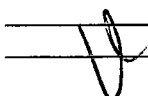
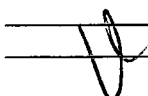
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ENSURE TUBE IS SEAMLESS

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 29786

Date: Thursday, 21/06/2007 9:57:52 AM
 User: Linda Lacelle

Process Sheet

Customer	: CC-DAR01 Dart Aerospace Ltd.	Drawing Name	: D2844-1/-3
Job Number	: 33029		
Estimate Number	: 10804		
P.O. Number	: N/A	Part Number	: D28441
This Issue	: 21/06/2007 S.O. No. : N/A	Drawing Number	: REWORK
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : R&D GENERAL	Drawing Revision	: N/A
Previous Run	: 00015	Material	: N/A
Written By	: 	Due Date	: 28/06/2007
Checked & Approved By	: 	Qty:	32 Um: Each
Comment	:		

Additional Product

Job Number:



Seq. #: Machine Or Operation:

Description :

1.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

REMOVE FROM STK:

4

D2844-1 B

32284 (13) / B 29785 (11)

FF 07-06-21 32

1

D2844-3 B

14087 x 2

SAD 07-06-21 32

2.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

REWORK PER NCR 172
PER DRWG D2844 REV.ASAD 07-06-21 32
FF 07-06-21
SB 07/06/21 (32)

3.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

CA-06-25
D2844-3 (2)
D2844-1

(PTO)

4.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

ID & STK
USING SAME BV/N

(9) B 32284 27/6/26
 (2) B 14087
 (8) B 29785

Date: Thursday, 21/06/2007 9:57:52 AM
User: Linda Lacelle

Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: D2844-1/-3

Job Number: 33029

Part Number: D28441

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC21

FINAL INSPECTION/W/O RELEASE



321

Comment: FINAL INSPECTION/W/O RELEASE

RD 07/06/26

Job Completion



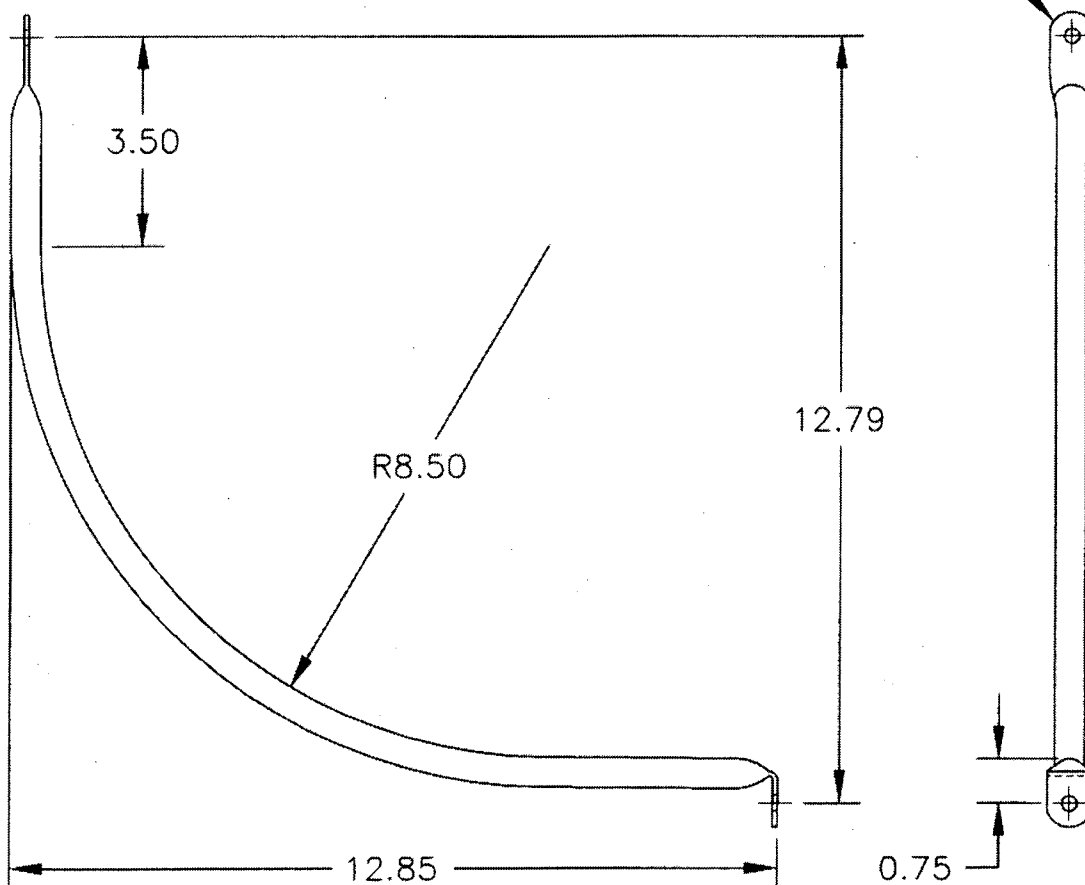
u 07/06/26



DESIGN <i>KE</i>	DRAWN BY <i>KE</i>	DART AEROSPACE USA, INC. FAIRCHILD INTERNATIONAL AIRPORT, WA	
CHECKED <i>DAH</i>	APPROVED <i>KS</i>	DRAWING NO. D2844	REV. A SHEET 1 OF 2
DATE 98.10.14		TITLE ARM	SCALE 1:3
A	98.10.14	NEW ISSUE	

RELEASED
98.11.11 KE

PUNCH ENDS PER SPEC CONTROL DRAWING D2727



D2844-1

MATERIAL: AISI 304/316 SS TUBE, $\varnothing 0.50 \times 0.035$ WALL
ENSURE TUBE IS SEAMLESS

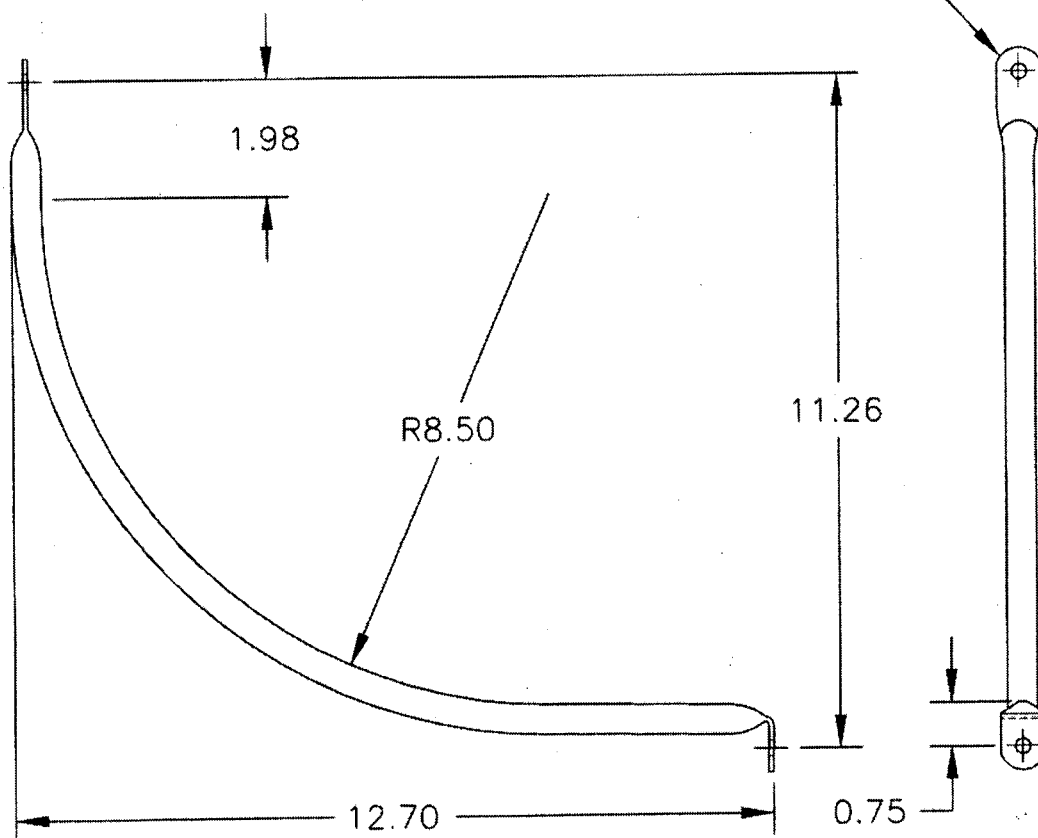
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3



DESIGN <i>KE</i>	DRAWN BY <i>KE</i>	DART AEROSPACE USA, INC. FAIRCHILD INTERNATIONAL AIRPORT, WA	
CHECKED <i>DAH</i>	APPROVED <i>KE</i>	DRAWING NO. D2844	REV. A SHEET 2 OF 2
DATE 98.10.14		TITLE ARM	SCALE 1:3

RELEASED
18.11.11 KE

PUNCH ENDS PER SPEC CONTROL DRAWING D2727



D2844-3




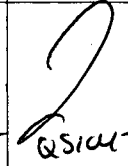
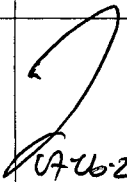
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FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
	2.0	4x 8x 22844-1 4x 32284 & 4x 329785 were kinked during the restband, ovalizing the tubing causing a weak spot in the strut. Root Cause: Human error.	 05/06/25	Qty 8 Scraps destroyed	 07/06/25	 07/06/25	 05/06/25	 07/06/25

NOTE: Date & initial all entries